

Date: Thursday, 15/01/2009 11:15:16 AM
 User: Julie Dawson

Process Sheet

split

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : PANEL-350 FWD CANOPY
 Job Number : 44821 -2
 Estimate Number : 13099
 P.O. Number :
 This Issue : 15/01/2009 S.O. No. :
 Prsht Rev. : NC Part Number : D36563
 First Issue : 11 Type : THERMOFORMING Drawing Number : D3656 REV B
 Previous Run : 43889 Drawing Revision : B
 Written By :
 Checked & Approved By : JUD 09.01.15
 Comment : Est. Rev. A 07/12/13 New Issue DL verified by:DD
 Est. Rev. B 08/09/25 Dwg. Update DL

①

②

Qty: Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MLEXS093F600607	GE PLASTICS LEXAN SHEET
-----	-----------------	-------------------------



Comment: Qty.: 34.6600 sf(s)/Unit Total : 138.6400 sf(s)

GE PLASTICS LEXAN SHEET

batch: M107574

BB 09/01/24

2.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
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Comment: HAND FINISHING THERMOFORMING

1) Cut Blanks to fit frame size

BB 09/01/24

3.0	THERMOFORMING	THERMOFORMING MACHINE
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Comment: THERMOFORMING MACHINE

Thermoform as per Dwg. D3656-3 and Folio FTA 016 using tool DT8987

Dwg. Rev. B

Folio Rev. C

BB 09/01/24

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Visually inspect for proper formation of each part

BB 09/01/24

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PANEL-350 FWD CANOPY

Job Number: 44821

Part Number: D36563

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

S 09/01/26 (X)

6.0

HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

1) Trim to Finished Dimensions as per dwg D3656

BB 09/01/26

7.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Check dimensions to ensure conformity to drawing tolerances.

BB 09/01/26

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/01/26 (X)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

PPP44641

SS 09/01/26 (X)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/01/27 (X)

Job Completion



W 09/01/27

DART AEROSPACE LTD		Work Order: 44821
Description: Panel		Part Number: D3656-3
Inspection Dwg: D3656	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Shape Definition	✓			
Free of visual flaws (bumps, cracks, voids, etc.)	✓			

Measured by: JB

Date: 09/01/26

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.040	Min	.053	✓			
0.045	Min	.044	✓			
0.050	Min	.055	✓			

Measured by: JB

Date: 09/01/26

Audited by: S

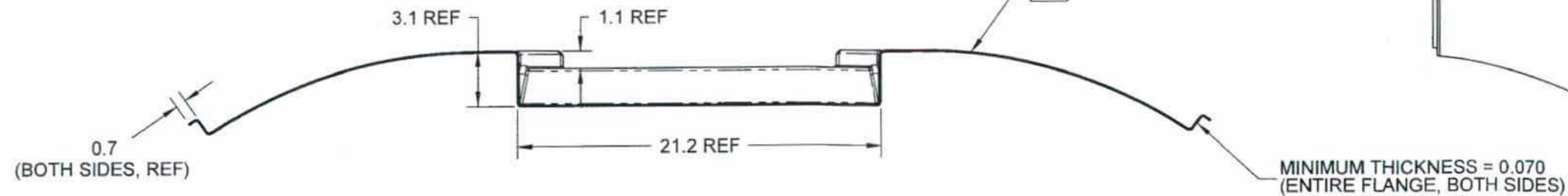
Date: 09/01/26

Prototype Approval:

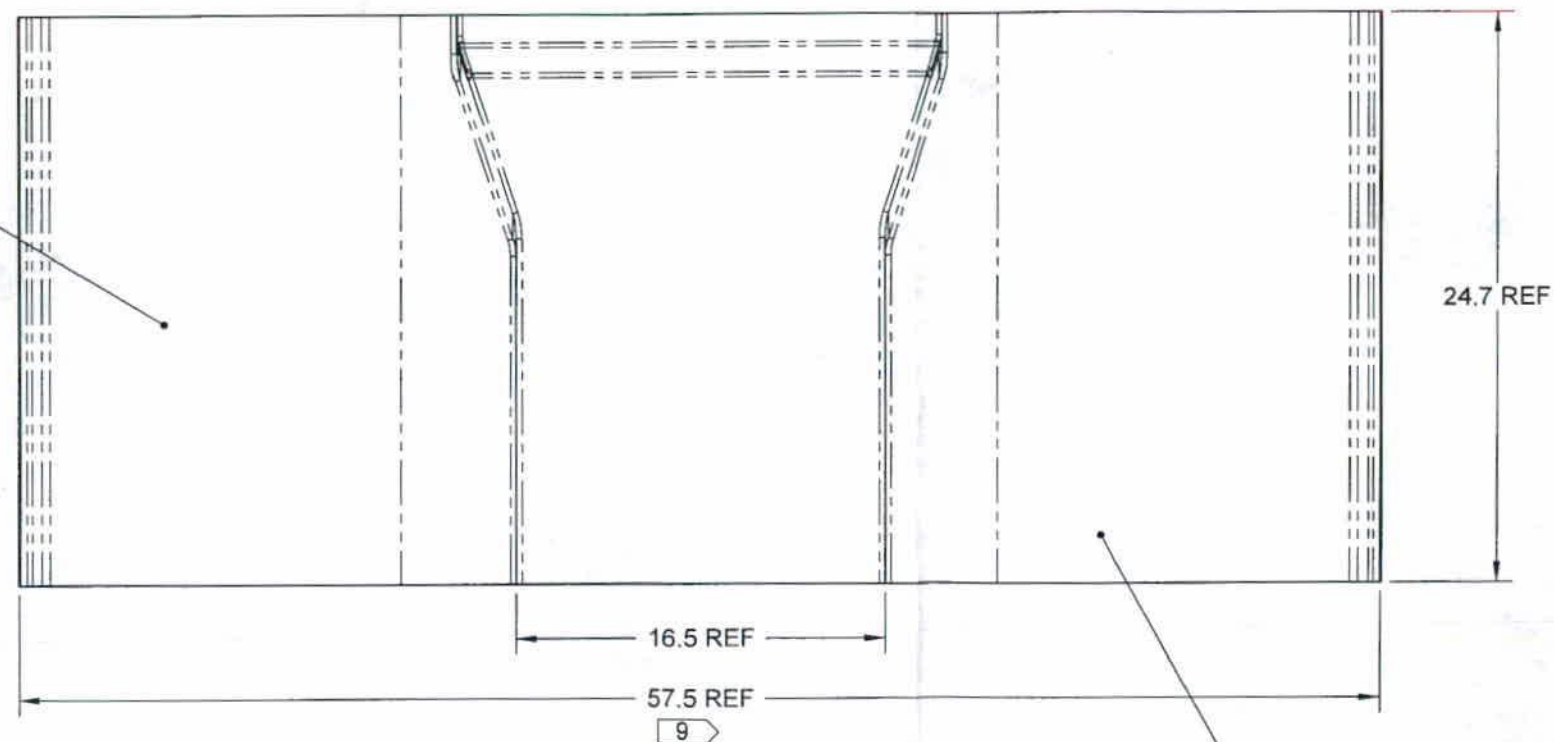
N/A

Date: N/A

Rev	Date	Change	Revised by	Approved
A	08.05.28	New Issue	KJ/DL	AS



TEXTURED SURFACE
ON THIS SIDE



D3656-1 PANEL

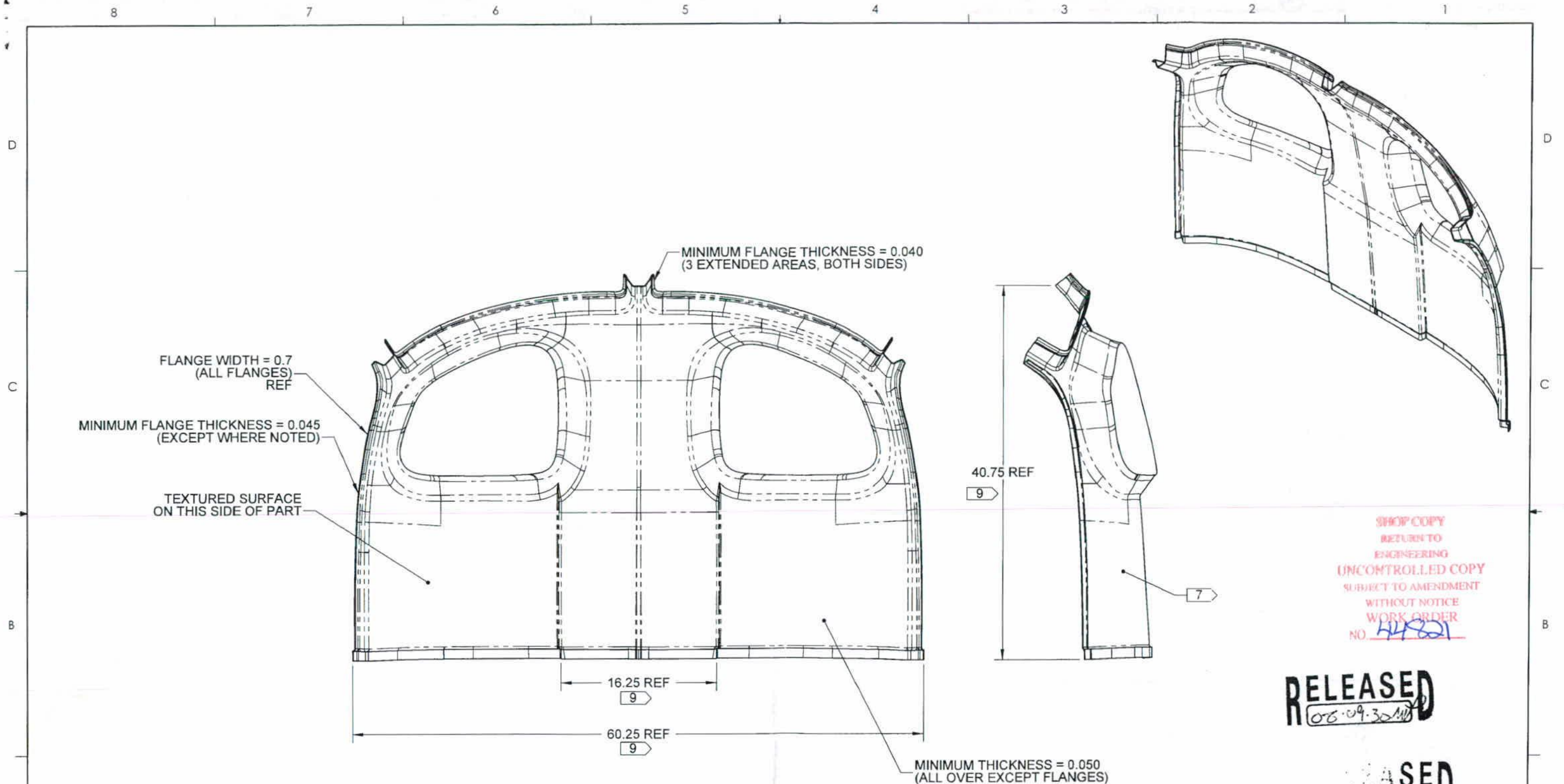
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WORK ORDER
NO. H4821

RELEASED
08-09-30 11:11

NOTES:

- 1) MATERIAL: F6006 SUEDE/POLISHED GY5B133 LIGHT GREY LEXAN SHEET 0.093 THICK
(REF DART SPEC MLEXS.093-F6006-07)
- 2) TOOLING: THERMOFORM PER MOLD DT8986 PER QSI 022
TRIM PER DT8986
- 3) FINISH: NONE
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: ETCH P/N AND B/N ON SMOOTH SIDE OF PART
- 8) WEIGHT: 6.6 lbs
- 9) DIMENSIONS TAKEN WITH PART IN MOLD WHERE INDICATED

B	REMOVE SKYLIGHT CUTOUTS, UPDATED NOTE 2 (A6-2); REASON: EASE OF MANUFACTURE AND CUSTOMER REQUEST	PH	08.09.18
A	NEW ISSUE	LE	08.03.03
REV.	DESCRIPTION	BY	DATE
DESIGN	LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	PH		
CHECKED	LE	DRAWING NO.	REV. B
MFG. APPR.	LE	D3656	SHEET 1 OF 2
APPROVED	LE	TITLE	SCALE
DE APPR.	LE	PANEL	NTS
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NO. 44821

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06-09-30-118

RELEASED

NOTES:

- 1) MATERIAL: F6006 SUEDE/POLISHED GY5B133 LIGHT GREY LEXAN SHEET 0.093 THICK
(REF DART SPEC MLEXS.093-F6006-07)
- 2) TOOLING: THERMOFORM PER MOLD DT8987 PER QSI 022
TRIM PER DT8987
- 3) FINISH: NONE
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: ETCH P/N AND B/N ON SMOOTH SIDE OF PART
- 8) WEIGHT: 8.7 lbs
- 9) DIMENSIONS TAKEN WITH PART IN MOLD WHERE INDICATED

DESIGN	LE	DART AEROSPACE LTD	
DRAWN	PA	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3656	SHEET 2 OF 2
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